Work Order ID 53794 November 18, 2009 12:42:28 PM	
Item ID: D3065-1 Accept Start Revision ID: B	i icaliidi biala ibi ilal ibbi
Item Name: Step Spacer Stop	
Start Date: 18/11/2009 Start Qty: 40.00 Cust Item ID:	en e
Required Date: 25/11/2609 Req'd Qty: 40.00 Customer:	
Reference:	
Approvals: Process Plan: Date Of 1/8 Tooling: Date:	
QC: Date: SPC (Y/N): Date:	
Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Work Center ID Description Run Hours Number Rev. Code Qty Qty	Reject Insp. Number Stamp
Draw Nbr Revision Nbr	
D3065 Rev B	
0.00	
FLOW CNC Waterjet 1-Cut as per Dwg D3065 Dwg Rev: Prog Rev: Deburr as required	(52)
110 QC2- Inspect parts off machine FAI/FAIB 0.00	•
QC Memo 0.00 Quality Control	
QC8- Inspect parts - second check QC Memo Quality Control QC8- Inspect parts - second check 0.00 752 0.00	·

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W/O:		WORK ORDER CH	WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		٠		17					
				. 1759					
•									
•				•					

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Ammerical						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
							•					
		•	-									

Quality Control



Page 2

November 18, 2009 12:42:28 PM Accept Item ID: D3065-1 Setup Start **Revision ID:** В Stop Step Spacer Item Name: Start Oty: 40.00 **Start Date:** 18/11/2009 Cust Item ID: **Required Date: 25/11/2009** Req'd Qty: 40.00 **Customer:** Reference: Run Start Tooling: Process Plan: Approvals: Date: Date: Stop **SPC (Y/N):** Date: Date: Set Up/ Plan Reject Reject Sequence ID/ Operation Draw Draw Accept Insp. Number Stamp Qty Qty **Work Center ID** Description **Run Hours** Number Rev. Code 0.00 130 Small Fab 0.00 Small Fab Memo Deburr if necessary. Small Fab 0.00 140 SB 09/12/14 52 NC BRAKE Brake NC Memo Bend as per Dwg D3065 Brake NC QC5- Inspect part completeness to step on W/O 0.00 150 27 8 09/12/15 Memo

Dart Aerospace	e Ltd
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W/O:			WC	RK ORDER CHANG	ES					r
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· · · · · · · · · · · · · · · · · · ·										
·										
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	l: Yes N	lo DQ/	A:	_ Date: _	
	Re	esolution:	Disposition	1:	_ QA:	N/C Clo	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE	(NCR))			
DATE STEP		Description of NC			on B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector	
									·	
	·	,						•		
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										1

Work Order ID 53794 November 18, 2009 12:42:28 PM

Page 3

Item ID:

D3065-1

Accept

Setup Start

Item Name:

Revision ID: В Step Spacer

18/11/2009

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Reject

Qty



Required Date: 25/11/2009

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Stop

Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

160

HandFinish

Hand Finishing

Operation **Description**

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

0.00

4112116

Draw

Rev.

Plan

Code

152

Accept

Qty

0.00

170

Quality Control

QC3- Inspect Part Finish

1/209-1217

180

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

St 09/12/17

0.00

Memo

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CH	IANGES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					. 6.					
					t n ft					
Part No		PAR #:	Fault Cate	gory:	N	CR: Yes	No DQ	A :	Date:	
	R	esolution:	Disposition	n:	Q	A: N/C CI	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFO	ORMANO	E (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Se				Verific	ation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Descri Chief Eng	ption 	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector

В

Item ID:

D3065-1

Accept

Setup Start

Stop

Revision ID:

Item Name: Step Spacer

Start Date:

Start Qty: 40.00 18/11/2009 **Required Date: 25/11/2009**

Operation

Description

Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Start Run

Qty

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

190

QC21- Final Inspection - Work Order Release

Run Hours 0.00

Draw Number

Plan Draw Rev. Code

Accept Qty

Reject Reject Number

Insp. Stamp

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	GES					r Taran
DATE	STEP	PRO	OCEDURE CHAN			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,	,
		• •								z 1
						:				· <u>.</u>
				Annual Attraction						
Part No	•	PAR #:	Fault Categ	ory:	NCF	l: Yes I	No DQ	\ :	_ Date: _	
	Re	esolution:	Disposition	:	QA:	N/C Clo	sed:	·	Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Corrective Action			Section B Ve			Verification Approv		
- DAIL	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
					:					

Parent Item:

Comments:

D3065-1RevB

Parent Item Name: Step Spacer



Start Date: 18/11/2009

Required Date: 25/11/2009

Page 1

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040	(3-0-4)	Purchased	No			100	sf	555.4571	5.2126	6.7763		
											189-12-8	3

2024-T3 .040 sheet

Warehouse	Loc Qty	Loc Code	1
Location			
Main Warehouse			
MAT	555.4570789		·
110305	192		
110337	6.4		
111786	32.0665789		
112291	50.1264		1
112331	82.8641		
113162	192		113162

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W/O:			W	ORK ORDER CHANG	ES	-			š **
DATE	STEP	PROCEDURE CHANGE By Date Qty Ch			Approva Chief Eng Prod Mgr	Approvar			
			, sis - 40-						
	!								
		·							
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No	DQA: _	Date:	
	Re	esolution:	Dispositio	n:	_ QA: N/C	Close	d:	Date:	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verification Approva		i Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		Section C	Chief Eng	QC Inspector
							·· <u>·</u> ·······		

DART AEROSPACE LTD	Work Order:	53794
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	249	Ħ			
2.093	+/-0.010	190.6	صر			·
3.936	+/-0.010	3,935	X			
4.186	+/-0.010	4.187	y			
0.587	+/-0.010	-585	.0			
Ø0.128	+0.005/-0.001	1132	8			
R0.125	+/-0.010	194				.,
3.465	+/-0.010	3,468	٠			
Ø1.250	+0.012/-0.001	1.260	10			
0.368	+/-0.010	.368	7			
0.871 (Pitch)	+/-0.005	-615	8			
0.040	+/-0.010	1010	8			
						-
						·
					1 · ·	

Measured by:	Audited by:	Prototype Approval:	a	
Date: 413-9	Date: 07/12 08	Date:		<u>^</u>

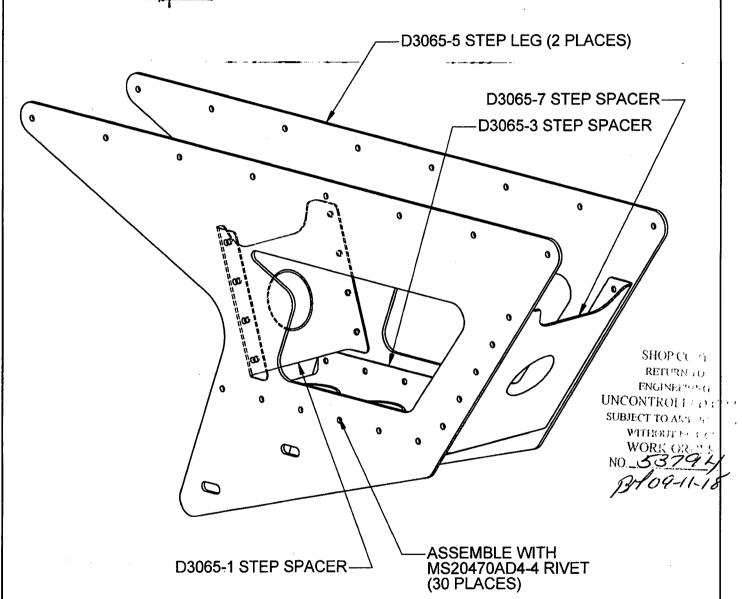
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	06.06.23	Dwg Rev. changed	KJ/JLM	1
С	07.02.07	Dimension 0.040 added	KJ/JLM A	<u> </u>
	L		· · · · · · · · · · · · · · · · · · ·	/ /



DESIGN A DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECK		APPROVED	DRAWING NO.	REV. B		
	PH	一根	D3065	SHEET 1 OF 5		
DATE	00.0)E 00	TITLE	SCALE		
	06.0	05.23	STEP LEG ASSEMBLY	1:2		
Α	0:	2.09.11	NEW ISSUE			
В	B 06.05.23		ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5			

RELEASED

06 cb 20 Aff



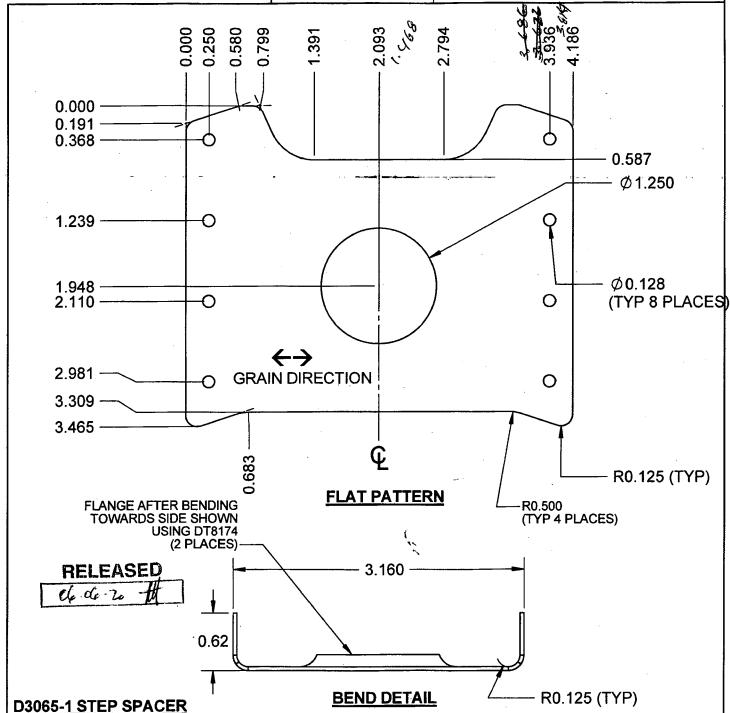
D3065-041 STEP LEG ASSEMBLY

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DRAWN BY DART AEROSPACE LTD CB HAWKESBURY, ONTARIO, CANADA

DART

DESIGN APPROVED. DRAWING NO. CHECKED REV. B PH D3065 SHEET 2 OF 5 TITLE DATE **SCALE** 06.05.23 STEP LEG ASSEMBLY 1:1



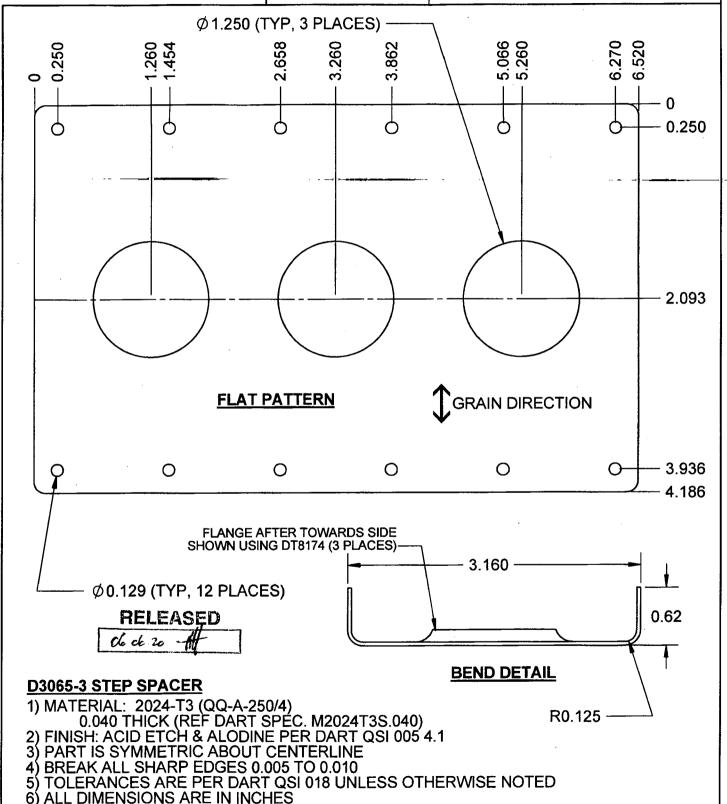
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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5379 DRAWN BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED_ DRAWING NO. CHECKED REV. B PH D3065 SHEET 3 OF 5 TITLE DATE **SCALE** 06.05.23 STEP LEG ASSEMBLY 1:1



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06.05. 72 .23 O DRAWING NO. STEP DART AEROSPACE LTL HAWKESBURY, ONTARIO, CANADA **G ASSEMBLY** SHEET 4 OF 5

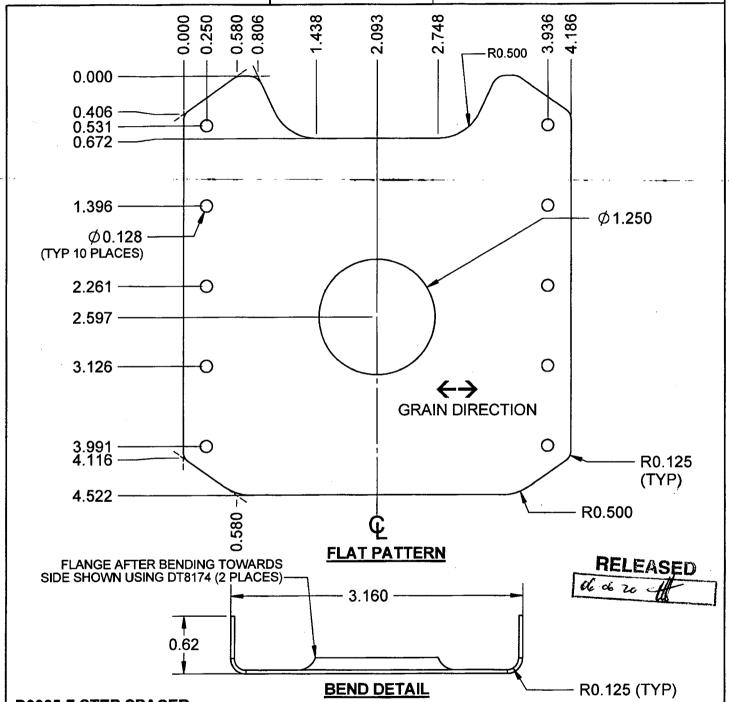
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SCALE

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DRAWN BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED. DRAWING NO. CHECKED REV. B PH D3065 SHEET 5 OF 5 TITLE DATE **SCALE** 06.05.23 STEP LEG ASSEMBLY



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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